



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D2892-1**Job Sheet 195400****Part No:** D2892-1**Job Qty:** 6 pcs**Part Name:** Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/21/19**Job Tracking No:****Due Date:** 6/14/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified by: DD IPP Rev:E 11.08.04
as per dwg rev.B DD verf:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	6/14/19		0.36	5.08	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	6 pcs	6/14/19		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Crosstubes - 2 - B4B	6 pcs	6/14/19		0.00	0.97	Crosstubes - 1 - B4B		
							Crosstubes - 2 - B4B		

DAS
64
9-89

MM 2019/06/13
2019/06/19

2019-06-13



Container No: S190259



Part: D2892-1

Job No: 195400

Serial No/Batch: S190259

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Hawkesbury, ON K6A 1K7
CANADA
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Date: 06/13/19

140 QC 3	6 pcs	6/14/19	0.00 0.00	Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	JUN 19 2019 DAS 40 9-89
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	6 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 28 9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

180 QC 21 - SA

6 pcs

6/14/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

JUN 21 2019

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA082

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Crosstubes) Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location:) LOCATION : LG050

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK077	D2892-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK077	3	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
2	2.250 Support	0.290Inches + 0.020 - 0.000	0.310 0.290		
3	2.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
4	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
5	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
6	2.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
7	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
8	2.250 Support	1.116Inches + 0.040 - 0.000	1.156 1.116		
9	2.250 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
10	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
11	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
12	2.250 Support	0.257Inches + 0.005 - 0.000	0.262 0.257		
13	2.250 Support	1.663Inches + 0.020 - 0.000	1.683 1.663		
14	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
15	2.250 Support	0.022Inches + 0.020 - 0.000	0.042 0.022		
16	2.250 Support	2.779Inches + 0.010 - 0.000	2.789 2.779		

Plex 5/21/19 1:36 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

DART AEROSPACE LTD		Work Order:	195400
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.150		.131	.132	.131	.131	.131
AB	0.290	0.310		.295	.297	.300	.300	.298
AC	0.040	0.060		.052	.052	.052	.052	.051
AD	0.115	0.150		.122	.124	.123	.123	.124
AE	0.240	0.260		.251	.250	.252	.251	.252
AF	0.188	0.193		.189Ø	.189Ø	.189Ø	.189Ø	.189Ø
AG	0.240	0.260		R.250 Ø	R.250 Ø	R.250 Ø	R.250 Ø	R.250 Ø
AH	1.116	1.156		1.143	1.141	1.139	1.139	1.140
AI	0.454	0.474		.473	.471	.469	.469	.470
AJ	0.240	0.260		R.250 Ø	R.250 Ø	R.250 Ø	R.250 Ø	R.250 Ø
AK	0.053	0.073		R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø
AL	0.257	0.262		.260Ø	.260Ø	.260Ø	.260Ø	.260Ø
AM	1.663	1.683		1.679	1.678	1.679	1.679	1.678
AN	0.053	0.073		R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø	R.063 Ø
AO	0.022	0.042		R.032	R.032 Ø	R.032 Ø	R.032 Ø	R.032 Ø
AP	2.779	2.789		2.782	2.783	2.782	2.782	2.782
AQ								
AR								
AS								
AT								

Accept/Reject **DAS**

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9-89

Measured by: MM Date: 2019/06/17

Audited by: mx Date: 19/06/14

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	<u>[Signature]</u>

DART AEROSPACE LTD		Work Order: 195400
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.115	0.150		.131				
AB	0.290	0.310		.296				
AC	0.040	0.060		.051				
AD	0.115	0.150		.122				
AE	0.240	0.260		.251				
AF	0.188	0.193		.189				
AG	0.240	0.260		R.250 OK				
AH	1.116	1.156		1.141				
AI	0.454	0.474		.469				
AJ	0.240	0.260		R.250 OK				
AK	0.053	0.073		R.063 OK				
AL	0.257	0.262		.260				
AM	1.663	1.683		1.678				
AN	0.053	0.073		R.063 OK				
AO	0.022	0.042		R.032 OK				
AP	2.779	2.789		2.782				
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: MUM	DAS	Date: 2019/06/14
Audited by: ONK	64	Date: 19/06/14
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	